



Dart Aerospace Ltd.
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D2332-041

Job Sheet 197699



Part No: D2332-041

Job Qty: 6 pcs

Part Name: Lid Prop Assembly 6.69"



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/12/19

Job Tracking No:

Due Date: 8/2/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV C1 IPP: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF IPP Rev:C 08-06-02 add comment DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier		
100	Small Fab - 1	6 pcs	8/2/19		0.32	1.88	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		Mach 2020-1-9
110	Small Fab - Brake NC - B4B	6 pcs	8/2/19		0.25	0.68	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 - B4B		
120	Small Fab - 2 - B4B	6 pcs	8/2/19		0.00	1.88	Small Fab - 1 - B4B		10/20/11/13
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		Mach 2020-1-
130	QC 5	6 pcs	8/2/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
140	Large Fab - Welded Assy-2-B4B	6 pcs	8/2/19		0.00	1.49	Large Fab - 1 - B4B		
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		MV Jan 15/20



Container No: S246722



Part: D2332 – 041
Job No: 197699
Serial No/Batch: S246722

Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
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Date: 01/13/20



Container No: S246722



Part: D2332-041

Job No: 197699

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Instructions: Various STC's

Date: 01/13/20

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					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
150 QC 9	6 pcs	8/2/19	0.00 0.00		QC 9 - 10	
					QC 9 - 18	
					QC 9 - 24	
					QC 9 - 43	
					QC 9 - 50	α
					QC 9 - 9	
160 QC 5	6 pcs	8/2/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	α
					QC 5 - 30	
170 Small Fab - 3 - B4B	6 pcs	8/2/19	0.00 1.88		QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	GP 20-01-20
180 QC 5	6 pcs	8/2/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
190 Packaging 3-1 - Stock - B4B	6 pcs	8/2/19	0.00 0.00		QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	

Plex 7/12/19 4:05 PM Dart.Renwick.Jennife

				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	DAS
				Packaging 3 - 23 - B4B	84
				Packaging 3 - 24 - B4B	9-89
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	DAS
				Packaging 3 - 36 - B4B	21
200	QC 21 - SA	6	8/2/19	QC 21 - SA - 21	9-89
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Small Fab) 1- Cut D2332-7 and D2332-5 to length as per dwg D2332. 2- Cut D2332-11 using DT8012 (need 2 per ass'y)

Descriptions: 7.735" long. 3- Debur.

110 - (Punch ends and deburr as per dwg) Punch and form D2332-11 to length as per dwg D2332 using DT8012 (need 2 per ass'y)

120 - (Small Fab) 1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459 (drill one per ass'y) 2- Ensure no foreign objects inside tube

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Weld per dwg A/R S.S. rod Batch M139028) Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)

*****ensure nothing is inside of tube before welding***** S.S Rod batch:

150 - (QC9- Inspect visual per QSI004- Fusion Welds)

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Small Fab) 1- Tumble 2- Assemble as per dwg D2332

180 - (QC5- Inspect part completeness to step on W/O)

190 - (Identify as per dwg & Stock Location:)

200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R0.250	304 SS Round bar .250	.6000 ft (.1 ea)	100-Small Fab - 1	5243099
M304TR1.000W.049	304 Round Tube 1.00 X .049W	2.5800 ft (.43 ea)	100-Small Fab - 1	5135662
M304TR0.500W.035	304 Round Tube .500 X .035W	7.5000 ft (1.25 ea)	110-Small Fab - Brake NC - B4B	5228562
AN4-4A	Bolt 345	12 Ea (1 ea)	170-Small Fab - 3 - B4B	195116
MS21042L4	Nut 303	12 6 Ea (1 ea)	170-Small Fab - 3 - B4B	228033
NAS1149D0416J	Washer 264	36 18 Ea (3 ea)	170-Small Fab - 3 - B4B	FM131511

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	M304R0.250	1	12	0
	M304TR1.000W.049	3	11	0
110-Small Fab - Brake NC - B4B	M304TR0.500W.035	8	145	0
170-Small Fab - 3 - B4B	AN4-4A	6	74	0
	MS21042L4	6	2,004	0
	NAS1149D0416J	18	1,871	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lid Prop Assembly	5.000Inches ± 0.030	5.030 4.970		
2	Lid Prop Assembly	1.250Inches ± 0.010	1.260 1.240		
3	Lid Prop Assembly	6.690Inches ± 0.010	6.700 6.680		